

**APPARATUS FOR SEPARATING FOULING CONTAMINANTS
FROM NON-CONDENSABLE GASES AT THE END OF A
PYROLYSIS/THERMOLYSIS OF BIOMASS PROCESS**

5 Field of Invention:

The present invention relates to the continuous collection of aerosol and liquid droplets from the gas stream resulting from a pyrolysis / thermolysis of biomass process before it causes fouling and coking/carmelization and, therefore,
10 operation stoppage of downstream equipment.

Background of the Invention:

The fast pyrolytic production of liquids from biomass has progressed with the
15 development of improved techniques. Such liquids are termed BioOil and are produced by converting organic residues such as forest and agricultural wastes in a fast pyrolysis process. BioOil is thermally unstable, being prone to polymerization/carmelization and thermal cracking when exposed to elevated temperatures for prolonged periods of time. These products are in the form of
20 gasses, aerosols, vapours and char. In this process, the char is first removed with cyclone separators. Because of the thermally unstable nature of the BioOil product normal surface condensers are inefficient and subject to extreme fouling. As well, the BioOil vapour is subject to chemical degradation. Consequently

most processes follow the cyclone separators with a quench tower for rapid cooling, condensation and coalescence of the BioOil. Nevertheless, there remains a significant amount of stable aerosols in the effluent gas stream.

Filtration or electrostatic precipitations are usually employed to clean the gas stream further. These systems are not ideal as they suffer variously from high-pressure drops, expensive maintenance or high capital cost. This is especially so for biomass feedstocks rich in resins and waxes, such as sugar cane bagasse and bark rich wood residues.

There are different types of the equipment available in industries such as oil and gas processing plants, which collect aerosol and liquid droplets from a gas stream such as scrubbers, filters, wet cyclones, mesh pad and impingement type separators. However, these are ineffective in capturing BioOil droplets and sub-micron aerosols.

BioOil droplets, which appear as liquid droplets, and sub-micron aerosols have different properties from hydrocarbon aerosols. Whereas hydrocarbon liquid evaporates at moderate temperatures, BioOil droplets are very sticky and will polymerize and eventually form coke if heated. Because of the sub-micron size of the aerosol, it is not possible to collect the entire aerosol with the above-mentioned equipment without special filters. The concentration of aerosol and liquid droplets constitutes approximately 20% of the BioOil production. Because of BioOil stickiness and the presence of other particles, filters will foul quickly.

Such filters are very expensive to replace and have problems associated with waste disposal.

5 The thermolysis / pyrolysis process and BioOil production with feedstocks that contain some wax and different types of extractives cause serious problems in the BioOil production process. These problems lead to an increase in production and maintenance costs. Problems such as equipment fouling, coking/caramelization and polymerization of BioOil aerosols in the gas compressor, gas heat exchangers and electrostatic precipitator increases the
10 production and maintenance cost and makes the continuous operation of the process difficult and expensive.

Techniques for separating aerosol and waxy components from the non-condensable or recyclable gases produced in a pyrolysis / thermolysis of
15 biomass process, especially when using bark and bagasse which contain wax and extractive, were previously unknown. Devices such as cyclones, scrubbers, filters, mesh pads and impingement type separators are not able to collect sub micron BioOil / wax aerosol from the gas stream at a low operation and maintenance cost.

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SUMMARY OF THE INVENTION

According to the invention there is provided a method of continuously capturing BioOil and its constituents from a gas stream produced in a fast

pyrolysis/thermolysis process, in a usable liquid form so as to produce a non-condensable gas free of fouling contaminants. The method includes separating BioOil and its constituents from a gas stream using hot inertial separation to maintain the temperature of said BioOil such that its sticky and/or thick constituents are at a temperature below its point of rapid degradation and above a point at which its viscosity is low enough to avoid inefficient operation of the separation equipment. Next the gas velocity is reduced to a temperature sufficiently low to allow droplets in the gas stream to settle out but high enough so that a viscosity of said droplets remains low enough to avoid inefficient operation of the separation equipment. Finally, a condensing step is carried out to condense the vapour in the gas stream.

The step of separating BioOil includes providing a first cyclone separator to collect liquid in a range of 5 microns and greater.

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The step of separating BioOil may include providing a meandering pipe following the cyclone separator to collect liquid having a sub-micron particle range and coalescing the BioOil droplets by means of inertial impaction.

20 The method may include providing a collection tank for collecting BioOil, wax and char coupled to a discharge outlet of the first cyclone separator.

A settling section may follow the hot inertial separation section, the settling

section operating in a temperature range of 30 to 50 degrees C. to increase retention time of the gas stream and slow down a rate of gas volume flow.

The settling section may include a gas tank.

- 5 The method may further include providing a condensation section operating in a temperature range of 5 to 20 degrees C. coupled to an outlet of the settling section, the condensation section operative to separate out and collect condensable materials from the gas stream. The condensation section may include a gas cooler.

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The method may include providing a second cyclone separator coupled to an outlet of said gas cooler operative to separate the condensate that has been re-entrained in the gas of the gas stream of the gas cooler.

- 15 A condensate collection tank may be coupled to an outlet of said second cyclone separator.

- The method may include return lines coupled to outlets of the first cyclone collection tank, the gas tank and the second cyclone collection tank operative to
20 return collected liquid to stored liquid BioOil that is coupled to an inlet of the first cyclone separator prior to the separation step.

In another aspect of the invention there is provided an apparatus for continuously

capturing BioOil and its constituents from a gas stream produced in a fast pyrolysis/thermolysis process, in a usable liquid form so as to produce a non-condensable gas free of fouling contaminants. The apparatus includes a separator operative to separate BioOil and its constituents from a gas stream and
5 to maintain the temperature of the BioOil and its constituents at a temperature such that its sticky and/or thick constituents at a temperature below its point of rapid degradation and above a point at which its viscosity is low enough to avoid inefficient operation of the separation equipment and a gas retention apparatus operative to reduce gas velocity with a temperature sufficiently low to allow
10 droplets in the gas stream to settle out but high enough so that a viscosity of said droplets remains low enough to avoid inefficient operation of the separation equipment.

The separator may be a first cyclone separator followed by a meandering pipe
15 coupled to an outlet of the first cyclone separator operative to collect BioOil droplets, wax, resin, char and aerosol in a sub-micron size and greater. A BioOil, wax and char collection tank may be coupled to a liquid outlet of the first cyclone separator.

20 The gas retention apparatus may be a gas tank which reduces gas velocity of the gas stream. A condensation section, operating in a temperature range of 5 to 20 degrees C., may be coupled to an outlet of gas tank, the condensation section operative to separate out and collect condensable materials from the gas stream.

The condensation section may include a gas cooler. A second cyclone separator may be coupled to an outlet of the gas cooler to collect condensate that has been re-entrained in the gas stream in the gas cooler. A condensate collection tank may be coupled to an outlet of the second cyclone separator.

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The apparatus may include return lines coupled to outlets of the first cyclone collection tank, the gas tank and the condensate collection tank, operative to return collected liquid to BioOil stored in a product tank coupled to an inlet of the first cyclone separator.

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In general, the method and apparatus, referred to as the Hot Back End System has the following benefits:

1. It reduces the moisture and aerosol load on a downstream electrostatic precipitator, making it possible to reduce the electrostatic precipitator size by 70%
2. It produces all captured products and component in an easily handled liquid form.
3. It substantially reduces or eliminates the following:
 - condensation on the electrostatic precipitator insulators
 - electrostatics precipitator electrode fouling
 - compressor fouling
 - gas heat exchanger fouling

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- gas cooler fouling
- scaling on the instruments
- the pressure drop associated with filtration equipment
- environmental issues such as waste disposal due to filter or mesh replacement

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This invention is intended for placement after the quench tower of a biomass pyrolyser. Optionally, an electrostatic precipitator of small size may follow this system. The Hot Back End System has the effect of reducing the loading on the electrostatic precipitator or filter and to substantially or completely remove the need for cleaning them.

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Brief description of the drawing

Further features and advantages will be apparent from the following detailed description, given by way of example, of a preferred embodiment taken in conjunction with the accompanying drawings, wherein:

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Fig. 1 is a schematic of the Hot Back End System.

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DETAILED DESCRIPTION WITH REFERENCE TO THE DRAWING

Referring to Fig. 1, the pyrolysis/thermolysis process has three components, namely, a hot inertial separation section **17**, a hot sedimentation section **20** and

a cold condensation section **22**. A product tank **10** receives pyrolyzed biomass or BioOil and other constituents which have been quenched by a quenching tower along line **11**. The liquid droplets and gaseous product leaves the tank **10** along line **13** and enters a cyclone **12** in the hot inertial separation section **17**

5 whose temperature is maintained in the range of 30 to 60 degrees C. The cyclone **12** acts as a centrifugal separator to separate the liquid BioOil of a size of 5 microns or more, aerosols, char, and wax from the gas. The liquid and other constituents are collected in a tank **14** whereas the gas is directed to a meandering pipe arrangement **16** where it undergoes inertia and impingement

10 separation in the same temperature range as cyclone **12**. This temperature range is above the sticky temperature of the waxes, extractives and aerosols. From the meandering pipe **16**, the gas travels to gas tank **18** in the hot sedimentation section **20** which is kept at a temperature in the range of 30 to 50 degrees C. The gas tank **18** slows down the gas volume flow and separates the

15 liquid from the gas stream with the help of gravity and an increased retention time. Gas from the gas tank **18** flows out to a gas cooler **24** located within a cold condenser section **22** the temperature within which is maintained in the range of 5 to 20 degrees C. The gas cooler **24** further separates condensables from the non-condensable gas. The gas from the gas cooler **24** is next directed to

20 another cyclone **26** for separation of the condensate re-entrained in the gas cooler **24** from the non-condensable gas. Finally condensate from second cyclone **26** is collected in a condensate collection tank **28**. Liquid collected from the first cyclone collection tank **14**, from gas tank **18** and condensate collection

tank **28** is returned through pump **30** along liquid return line **32** to the product tank **10** where it is mixed with stored liquid BioOil.

The system consisting of the cyclone **12**, a special high velocity meandering
5 piping arrangement with several 90° turns **16**, a gas tank **18**, a gas cooler **24** and another cyclone **26** is referred to herein as a Hot Back End System.

A Hot Back End System is located after the quench tower in a biomass pyrolysis / thermolysis system. The hot inertial separation section **17** can be made up of a
10 variety of inertial devices maintained at a temperature of 30 to 65 °C for the removal of heavy tars, waxes and residual char. The cool section **22** which includes the gas cooler **24** maintained in 5 to 20 °C. range has a second set of inertial devices for the removal of light liquids. The inertial devices may comprise cyclones, impactors and settling tanks.

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Depending on the process condition approximately 10 to 50 % of the total production of BioOil in the form of the vapours, aerosol and BioOil droplets travel with the recycled gas or non-condensable gases out from the hot product tank **10**. It is necessary to separate these liquids from the non-condensable gases
20 before it enters the electrostatic precipitator and the compressor (not shown) and other parts of the process equipment. The first stage of separation is right after the hot product tank **10**, in which the cyclone **12** separates approximately 3 to 21% of the liquid consisting of BioOil, waxes, extractives, water and char from

the non-condensable gases. The second stage consisting of the special meandering piping **16** and the gas tank **18** is the most efficient liquid separation part the of the Hot Back End system, separating approximately 4 to 14% of the liquid consisting of wax, BioOil, extractives, water and char. The collected liquid

5 in this part is very viscous. Up to this point almost all the aerosol, wax, char, and BioOil droplets have been disengaged, and the non-condensable gases that are moving forward to the next step of liquid separation are free of these fouling contaminates. It is very important before the non-condensable gases enter the gas cooler that they be free of BioOil and especially wax, otherwise these

10 products will rapidly foul the gas cooler. The last stage of the Hot Back End system is a gas cooler and another cyclone to disengage the condensable from non-condensable gas. In the gas cooler and the last cyclone, 9% of the remaining liquid disengages from non-condensable gases. Approximately one percent of contaminates, which are free of BioOil and wax, travel to the

15 electrostatic precipitator, which is not part of the Hot Back End system. The Hot Back End system is very low in maintenance and operating costs.

The product tank **10**, the first cyclone **12**, the meandering pipe **16** and the gas tank **18** need to be kept hot in order to keep all the wax / resin and BioOil in a

20 single phase. Next the wax/resin and BioOil are transferred to the gas cooler **24** and the last cyclone **26** to be chilled and condensed. The preferred temperature for each section of the Hot Back End System is as follows:

- (1) Depending on the type of feedstock, the feed rate and the gas stream velocity, the product tank **10** operating temperature range is from 35 to 65°C depending on the process condition mentioned above.

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- (2) The first cyclone **12** operating temperature range is from 30 to 60°C depending on the process condition mentioned above.

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- (3) The meandering pipe **16** operating temperature range is from 30 to 60°C depending on the process condition mentioned above.

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- (4) The gas tank **10** operating temperature range is from 30 to 50°C depending on the process condition mentioned above. Up to this point the system has to be warm, otherwise wax/resin in the system separates and, if it cools down, the wax / resin viscosity will increase and cause a problem for the pump and instruments such as the level controller, the side glass and also the check valves.

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- (5) The gas cooler **24** operating temperature range is from 5 to 20°C depending on the process condition mentioned above.

- (6) The last cyclone **26** operating temperature range is from 7 to 25°C depending on the process condition mentioned above.

The purpose and operating condition of each section of the Hot back End System depends on the type of feedstock, feed rate and gas stream velocity as follows:

- 5 The first cyclone **12** collects BioOil droplets, wax / resin, char and aerosol greater than 5 microns in size. This cyclone **12** collects 3 to 21 % of the total BioOil production. The vapour velocity is in the range of 2000 to 8000 FPM with a pressure drop from 0.5 to 5 inch of water. By employing cyclone **12** and collecting the liquid, the load and pressure drop on the second stage of
- 10 separation, namely, the meandering pipe, will be reduced.

- The meandering pipe **16** and the gas tank **18** collect BioOil droplets, wax / resin, char and aerosol of sub micron dimensions and greater. The meandering pipe **16** and the gas tank **18** collect 4 to 14 % of the total BioOil production. The vapour
- 15 velocity in the meandering pipe **16** is in the range of 4000 to 16000 FPM. The pressure drop across the meandering pipe **16** is in the range of 5 to 100 inch of water. In the meandering pipe **16** all contaminates in the gas stream such as wax/ resin, char and aerosol are substantially reduced or eliminated.

- 20 The gas tank **18** reduces the gas velocity for more retention time, which allows the droplets in the gas stream and from the meandering pipe **16** to settle down. The Vapour velocity in the gas tank is 10 to 40 FPM and the pressure drop is less than two inches of water. In special cases, a mesh pad can be installed at

the outlet of the gas tank **18**. There are no waxy contaminants to foul the mesh pad at the outlet of the gas tank **18**.

The gas entering the gas cooler **24** is free of fouling contaminants (wax / resin).

- 5 The gas cooler **24** chills down the vapour to substantially reduce or eliminate all condensate in the gas stream. Gas velocity in the gas cooler **24** is in the range of 1000 to 10000 FPM and the pressure drop is in the range of two to 20 inches of water. Plate, shell and tube or fin tube type heat exchangers (depending on the ambient temperature of the location) are all suitable.

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The second cyclone **26** collects the condensate that has been re-entrained in the gas stream in the gas cooler **24**. The gas velocity in this section is in the range of 4000 to 8000 FPM and the pressure drop 0.5 to 5 inches of water.

- 15 The condensate collected by the gas cooler and the last trap is rich in the organics mentioned in the analytical result table below and can be distilled, separated and recovered as a useful by-product.

- 20 An electrostatic precipitator (not shown) could follow the Hot Back End system to collect any escaped wax-free BioOil and escaped char. The size of this electrostatic precipitator is much smaller compared to that required without a Hot back end system.

Examples (Application of the invention)

The following tables, illustrate several examples of thermolysis runs and the collector's performance.

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TABLE 1

Sample examples of Hot Back End collection by devices in pyrolysis / thermolysis unit # 2 (15 tonne / day pre-commercial plant)

| | Percent of total BioOil production collected in each vessel | | | |
|------------------|---|--|--|---|
| Feed | Product tank | Cyclone#1 | Meandering pipe and gas tank | Gas cooler and Cyclone #2 |
| whitewood | 81.5 | 3.1 | 8.0 | 6.4 |
| whitewood | 77.1 | 4.4 | 5 | 12.8 |
| Whitewood / bark | 79.0 | 6.1 | 5.0 | 7.9 |
| Whitewood / bark | 83.0 | 5.3 | 4.2 | 6.4 |
| | BioOil | Viscous, BioOil, wax, Condensable and char | Viscous, BioOil, wax, Condensable and char | Yellowish condensate Free of BioOil and wax |

TABLE 2

**Sample examples of Hot Back End collection by devices in pyrolysis /
thermolysis unit # 1 (two tonne / day pilot plant)**

| | Percent of total BioOil production collected in each vessel | | | |
|---------------------|--|---|---|---|
| Feed | Product tank | Cyclone#1 | Meandering pipe and gas tank | Gas cooler |
| Fine bagasse | 79.6 | 3.8 | 5.8 | 10.8 |
| Semi-coarse bagasse | 70.7 | 10.7 | 11.2 | 7.3 |
| Coarse bagasse | 53 | 12.5 | 13.6 | 19.3 |
| Whitewood / bark | 62.8 | 20.6 | 6.9 | 6.9 |
| Whitewood / bark | 64.1 | 20.4 | 4.6 | 6.8 |
| | BioOil | Viscous, BioOil, wax, Condensable and char | Viscous, BioOil, wax, Condensable and char | Yellowish condensate Free of BioOil and wax |

TABLE 3

Analytical results of the liquid collected in each section of the Hot Back
End from fifteen tonne per day pyrolysis / thermolysis unit

| Components | Cyclone#1 (1st stage) Wt% | Gas tank and meandering pipe Wt% | Cyclone#2 (last stage) Wt% |
|-------------------|---|---|-----------------------------------|
| Char | 0.79 | 0.33 | 0.002 |
| H ₂ O | 45.2 | 44.7 | 83.3 |

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Accordingly, while this invention has been described with reference to illustrative embodiments, this description is not intended to be construed in a limiting sense. Various modifications of the illustrative embodiments, as well as other embodiments of the invention, will be apparent to persons skilled in the art upon reference to this description. It is therefore contemplated that the appended claims will cover any such modifications or embodiments as fall within the true scope of the invention.

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